

Work Order ID 127544

December-17-14 1:37:15 PM

127544

Page 1

Item ID: D3608-3

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Upper Doubler

Start Date: 12/17/14 Start Qty: 2.00

2

Cust Item ID:

Required Date: 12/17/14 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: MCS Date: 14-12-22 Tooling: _____ Date: _____Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3608

C

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3608

Dwg Rev: CProg Rev: C

2-Deburr if necessary

304-040

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

120

0.00

120

QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

(2)

DE 15/01/06

(2)

DE 14/01/06

(2)

DAS
38
9-89

JAN 06 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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127544

Page 2

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 12/17/14 **Start Qty:** 2.00 ***2***

Cust Item ID:

Required Date: 12/17/14 **Req'd Qty:** 2.00 ***2***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run	Start	*NR1*
	Stop	*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150 Identify as per dwg & Stock Location: ST 205 0.00

150

Packaging	Memo	0.00
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Packaging

160	QC21- Final Inspection - Work Order Release	0.00
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160

QC	Memo	0.00
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Quality Control

DAS
65
9-89

JAN 07 2015

MLJ 15-01-08

15

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
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Picklist Print

December-17-14 1:37:14 PM

Page 1

Work Order ID: 127544

127544

Parent Item: D3608-3

D3608-3

Parent Item Name: Upper Doubler

Start Date: 12/17/14

Required Date: 12/17/14

Start Qty: 2.00

Required Qty: 2.00

Comments:

IPP Rev:A New Issue 07-03-26 JLM
 IPP Rev:B 08-10-15 preliminary issue DD verified by:EC
 IPP Rev:C 08-12-11 rev.A as per dwg DD verified by:EC IPP
 Rev:D 10.02.16 rev.B as per dwg DD verified by:EC IPP Rev:E
 10.11.17 as per PC1 dwg DD verified by:EC IPP Rev:F 10.11.29 as
 per revC dwg DD verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased	No			100	sf	257.5000	0.7392	2			

M304S20GA

304/316 .040 Sheet

Dec 15/01/06

Location

Loc Qty

Loc Code

MAT020

257.5

m130345

5.5

m131060

252

1.7361

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
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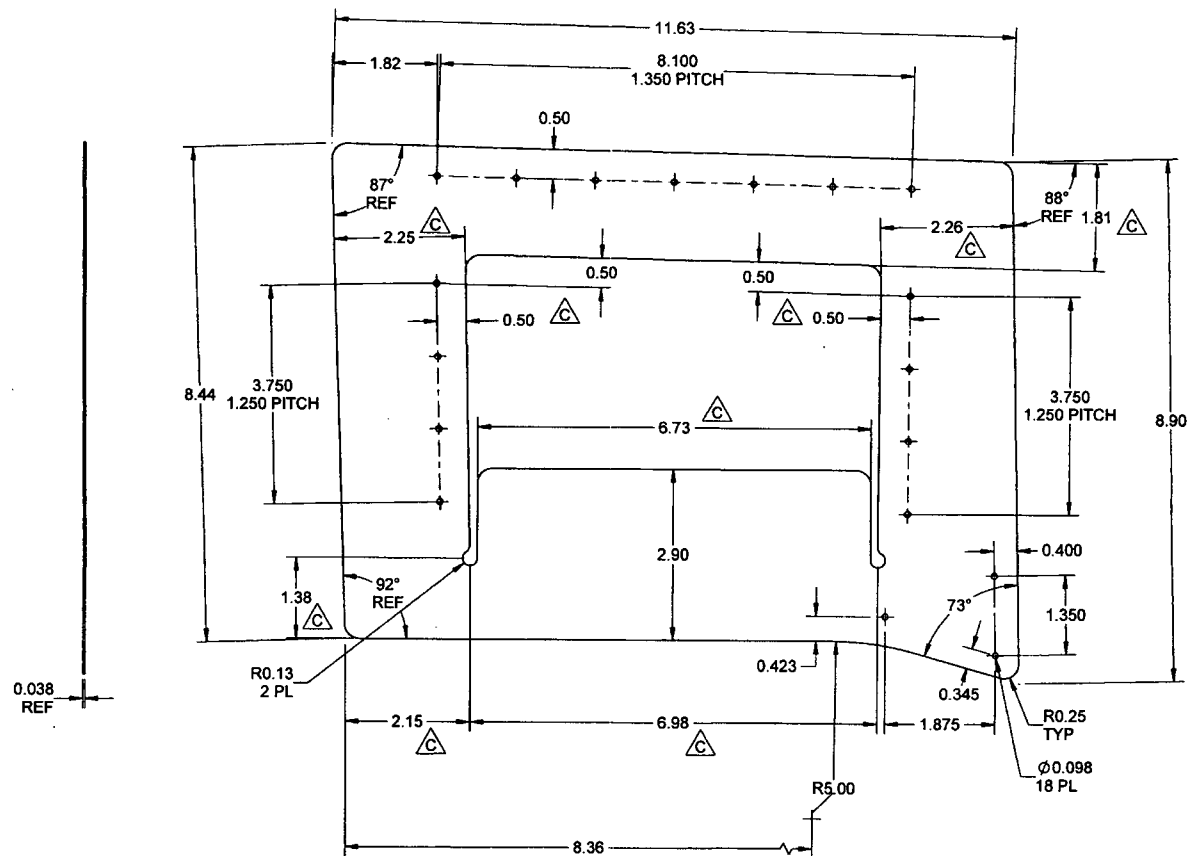
DART AEROSPACE LTD		Work Order: 127544
Description: Upper Doubler		Part Number: D3608-3
Inspection Dwg: D3608	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001	.099	✓		V=DC-02	
1.82	+/-0.030	1.82	✓		Tape	
0.50	+/-0.030	.50	✓			
11.50	+/-0.030	11.50	✓			
7.950	+/-0.010	7.959	✓			
1.325	+/-0.010	1.325	✓			
2.25	+/-0.030	2.25	✓			
8.50	+/-0.030	8.50	✓			
3.750	+/-0.010	3.749	✓			
1.250	+/-0.010	1.250	✓			
6.82	+/-0.030	6.82	✓			
2.46	+/-0.030	2.46	✓			
7.07	+/-0.030	7.07	✓			
11.63	+/-0.030	11.63	✓			
2.28	+/-0.030	2.28	✓			
1.44	+/-0.030	1.44	✓			
8.56	+/-0.030	8.56	✓			
2.00	+/-0.030	2.00	✓			
0.040	+/-0.010	.036	✓			

Measured by: <i>DC</i>	Audited by: <i>38</i> 9-89	Preliminary Approval:
Date: 15/01/06	Date: JAN 06 2015	Date:

Rev	Date	Change	Revised by	Approved
A	09.05.11	New Issue	KJ	
B	10.02.18	Dimensions updated per Dwg Rev B	KJ	
C	10.12.21	Dimensions updated per Dwg Rev C	KJ	<i>[Signature]</i>



THIS COPY
APPROVED
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WORK ORDER
NO. 127,544 MJS
14-12-22

RELEASED
2010-11-23

D3608-1 LOWER DOUBLER

- NOTES:
- 1) MATERIAL: AISI 304/316 SS SHEET, 20 GAUGE
PER MIL-S-5059, OR AMS 5513 (304) OR AMS 5524 (316)
OR ASTM A240 OR ASTM SA240
REF DART SPEC M304S20GA
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
 - 7) WEIGHT: 0.76 lbs

C	OFFSET TOP AND VERTICAL EDGES OF RECTANGULAR OPENING BY 0.250 OUTWARDS; UPDATE IDENTIFICATION REFERENCE	MB	10.11.19
B	OFFSET TOP AND VERTICAL EDGES OF RECTANGULAR OPENING BY 0.250 INWARDS; ELIMINATE D3608-1F1-3F; DELETED BENDING DETAILS. REASON: D3608-1/3 NOW SOLD TO CUSTOMERS UNBENT PER PAR#09-097	MB	10.02.05
A	NEW ISSUE	MB	07.04.11
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.11.19		
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